

Work Order ID 60106

June 24, 2010 11:39:26 AM

Page 1

Item ID: D2562-001

Accept

Setup Start

Revision ID:

Stop

Item Name: Strut

Start Date: 6/24/10 Start Qty: 2.00

Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2562

Rev D

100



Brake NC

Brake NC

NC BRAKE

Memo

Punch to length as per Dwg D2562

0.00

0.00

=> m.p w/06/24

(2x)

110



Small Fab

Small Fab

Small Fab

Memo

1- Bend end as per Dwg D2562 Angle "D" 12-Deburr

0.00

0.00

=> m.p w/06/24

(2x)

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/06/24

(+2)

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

M 114841

Memo

0.00

Powder Coating

START TIME:

3:50

OVEN TEMPERATURE:

400

FINISH TIME:

4:20

2 10-6-24

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6/25/25 (2)

150

Identify as per dwg & Stock Location:

264

0.00



Packaging

Memo

0.00

Packaging

6/25/25 (2)

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Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CL10/6/25

1000.25

Picklist Print

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Page 1

Work Order ID: 60106

Parent Item: D2562-001

Parent Item Name: Strut



Start Date: 6/24/10

Required Date: 6/25/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP 11F02.04.15 Added dwg Rev.B11 NG11

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	133.1750	1.7067	3.593053			



304 RD Tube .500 x .035W

Location

Loc Qty

Loc Code

MAT

113.21019

114482 ✓

113.21019

MAT014

19.96082

114356

19.96082

MAT017

0.004



112800

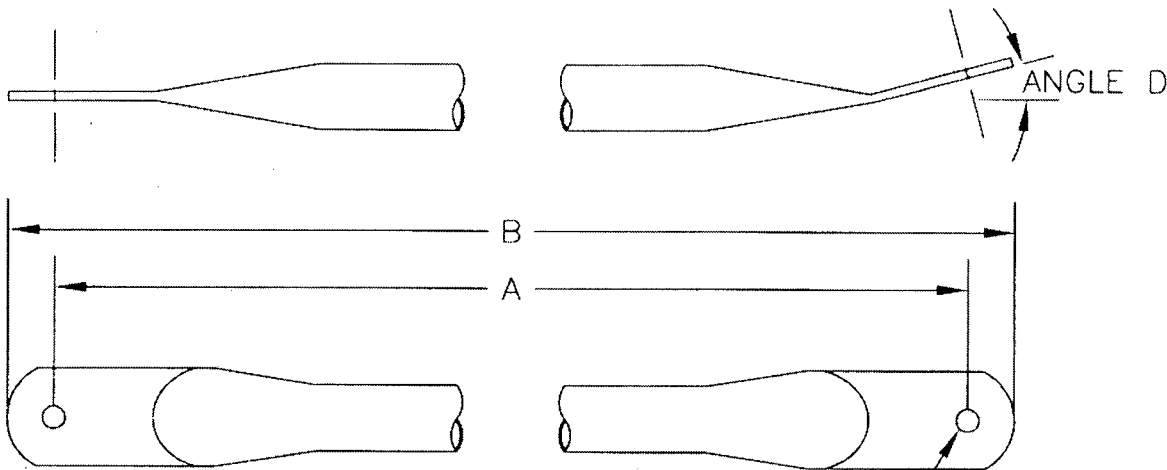
0.004

3.593053

M.K.
6/24/10



DESIGN		DRAWN BY		DART AEROSPACE LTD	
CP		RF		HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. D	
		D2562		SHEET 1 OF 1	
DATE	TITLE		SCALE		
05.05.18	STRUT		1:2		
A	96.05.01		NEW ISSUE		
B	98.10.15		UPDATED MATERIAL NOTE (TSR A603)		
C	02.06.05		ADD -005; ADD FINISH		
D	05.05.18		ADD -007/-011/-013; UPDATE -005		



"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

60106

RELEASED
05.05.27